

Date: Friday, 26/01/2007 1:59:14 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE		
Job Number	: 30486		Part Number	: D29331		
Estimate Number	: 10833		Drawing Number	: D2933 UNDER REVIEW		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 26/01/2007		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/02/2007		
Previous Run	: 29344		Qty:	4		
Written By	:		Um:	Each		
Checked & Approved By	:					
Comment	: Est: B00.06.26 New DWG rev (mpp 2069) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101001	7075-T7351 2X6X6.25	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: B23934	MS 07/01/30 4
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr	PTG MS 07/01/30 4
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	MS 07/01/31 4
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	MS 07/01/31 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.26	2	TOOL RAD FOR FLANGE POCKETS SHOULD BE RD.188				JP 07.01.26 PV 451042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 26/01/2007 1:59:14 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/0H-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 30486

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

RG 07-02-06

4

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

07-02-06

①

7.0 POWDER COATING POWDER COATING



M10314

ATTN: PAINT 1 pc grey

hx

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07/02/12

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

LC 7/02/12 (4)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



3W1172

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST480

PC 7/02/12 (4)

100%

10.0 QC21 FINAL INSPECTION/W/O RELEASE



④

Comment: FINAL INSPECTION/W/O RELEASE

07/02/13

Job Completion



4 07-02-12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order:	30484
Description: 206 Saddle, Inboard, Left side			Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.107	.128	.126	.126		
B	0.100	0.140		.107	.126	.126	.126		
C	0.100	0.140		.132	.138	.135	.135		
D	0.210	0.230		.220	.216	.220	.218		
E	1.245	1.255		1.251	1.251	1.251	1.251		
F	1.245	1.255		1.251	1.251	1.251	1.251		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.118	.118	.118	.118		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.506	.502	.505	.505		
Q	3.715	3.725		3.720	3.718	3.718	3.718		
R	2.470	2.510		2.493	2.495	2.495	2.495		
S	0.240	0.270		.240	.250	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.370	1.368	1.370	1.370		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.144	1.130	1.130	1.130		
Y	1.565	1.585	DT8695 A/B	1.583	1.569	1.568	1.569		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	MS	Audited by:	SC
Date:	07/01/10	Date:	07.02.06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	

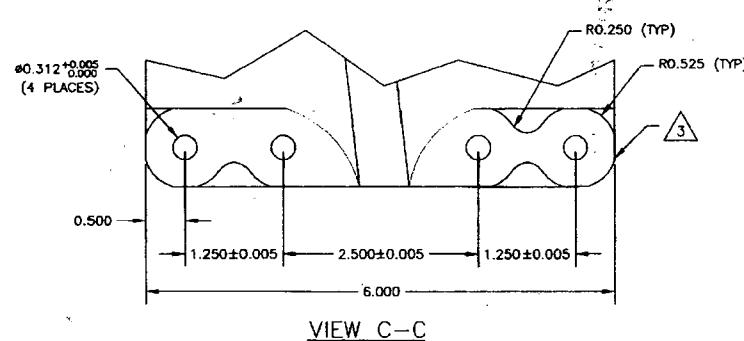
W/O:		WORK ORDER CHANGES					
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0702130	2	I part scrap, grain direction wrong direction on batch of billets, we can still machine billets placing them differently in jig.	QS1042	Check billets before machining. Destroy & Retain	BC 07.02.06	07.02.06	QS1042	07.02.06

NOTE: Date & initial all entries

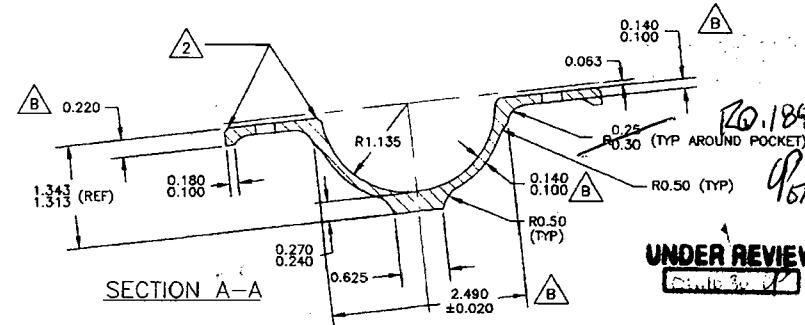
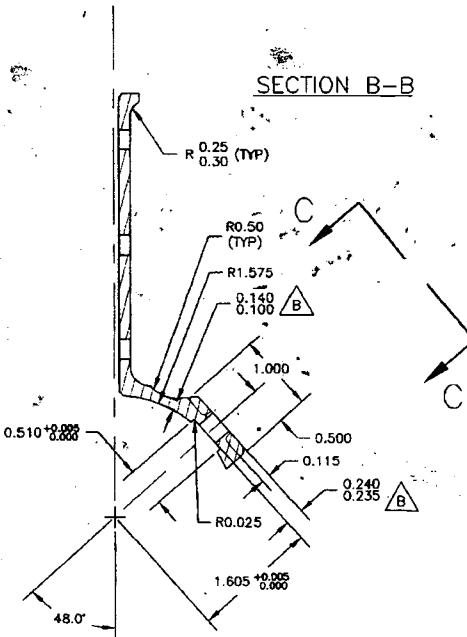


VIEW C-C

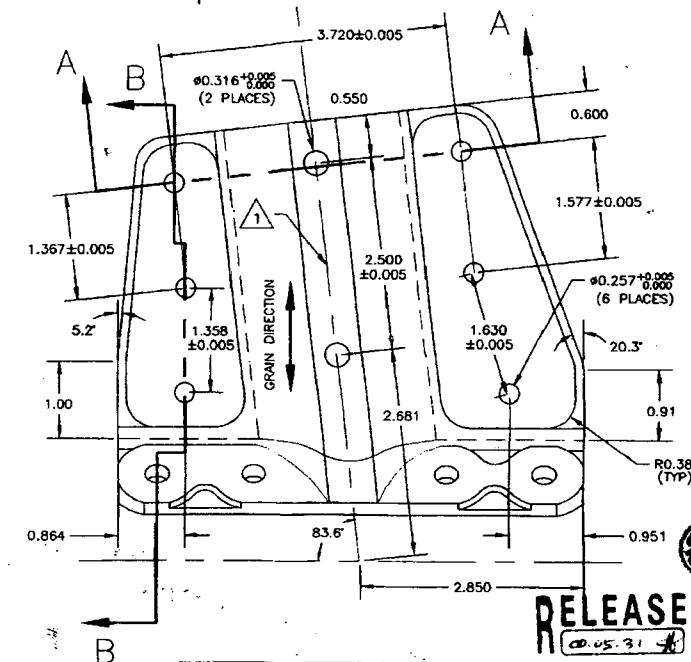
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (Q0-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE
- 3 CHAMFER 0.050" x 45°



UNDER REVIEW
DRAFT 30/10/2016



RELEASED
00.05.29

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B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. RELOUE, VA
CHECKED	APPROVED	DRAWING NO. REV. B D2933 SHEET 1 OF 1
DATE	TITLE	SCALE 00.05.29 SADDLE INSIDE 2:3

CD071101/2016
DRAFT 30/10/2016

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NOTE: Date & initial all entries

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle
Importance: High

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well. See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge

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No virus found in this incoming message.
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Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

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